



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3066-1
Job Sheet 168078



Part No: D3066-1

Job Qty: 20 ea

Part Name: Spacer



Part Weight: 0 lbs

Job Created: 11/9/17

Due Date: 11/12/17

Type: Stock

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		11/11/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	20 pcs		11/11/17	0.00	0.71	Waterjet1		SC
120	QC	20 pcs		11/11/17	0.00	0.00	QC8		38
130	HandFinish	20 pcs		11/12/17	0.00	0.31	HandFinish1		2017-11-16 JSC
140	QC	20 pcs		11/12/17	0.00	0.00	QC7		38
150	Packaging	20 pcs		11/12/17	0.00	0.00	Packaging3	WAOB	NOV 17 2017
160	QC21-SA	20 Ea		11/12/17	0.00	0.00	QC21		6

Part Op 100 - 1-Cut as per Dwg D3066

Descriptions: 150 - *** STOCK IN STEP CELL***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.080	2	69	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.128inches + 0.005 - 0.000	0.133 0.128		
2	Spacer	0.708inches ± 0.010	0.718 0.698		
3	Spacer	0.354inches ± 0.010	0.364 0.344		
4	Spacer	0.354inches ± 0.010	0.364 0.344		
5	Spacer	2.250inches ± 0.005	2.255 2.245		
6	Spacer	16.450inches ± 0.010	16.460 16.440		
7	Spacer	0.080inches ± 0.010	0.090 0.070		

PART NO:
Revision:
Operation:
Change No:

Spacer



DART
AEROSPACE
S010422

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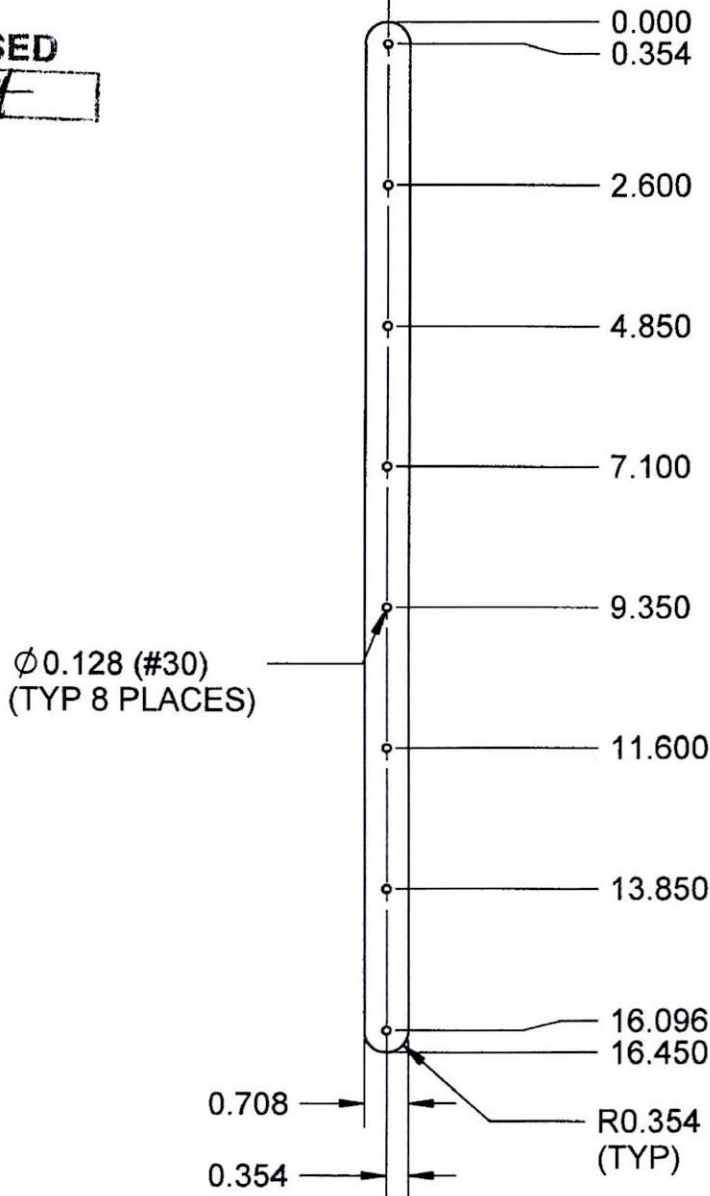
D3066-1
Start up Operation

Mfg Date: 11/15/17
Job No: 168078



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	RE SHEET 1 C
DATE 06.05.29		TITLE SPACER	SCALE 1:1
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED
de.de-20



NOV 13 2017

DAS
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WITHOUT NOTICE
WORK ORDER
168078

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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